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5706

648.4704

Job Sheet 183196



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul Provisions



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

5114435

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Small Fab-3		Smb
100	Small Fab	1 pcs	10/5/18	10/5/18	0.00	1.00	Small Fab-3		SMB
120	QC	1 pcs	10/5/18	10/5/18	0.00	0.00	QC4		38
121	DC	1 pcs	10/5/18	10/5/18	0.00	0.00	DC		9-89
130	Packaging	1 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-1		21
140	QC21-FG	1 Ea	10/5/18	10/5/18	0.00	0.00	QC21		21

Part Op 100 - Pick bag and tag
Descriptions: 121 - Supply owner's & overhaul procedures manual

OCT 0 5 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer	3 Ea (3 ea)	90-Start up Operation	5056461
NAS1149F0563P	Washer	8 Ea (8 ea)	90-Start up Operation	fm137544-25
188-FSCS-1032-5/8	Set Screw	4 Ea (4 ea)	100-Small Fab	5067901-1
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	5108235
600.1312	Caution Sticker	1 Ea (1 ea)	100-Small Fab	5098056
AN4-23A	Bolt	2 Ea (2 ea)	100-Small Fab	fm123434
AN5-21A	Bolt	4 Ea (4 ea)	100-Small Fab	fm137951-44
C2-14-2	Label Rivets	2 Ea (2 ea)	100-Small Fab	5071344
C45-10-1	Lock Spring Pin	1 Ea (1 ea)	100-Small Fab	5057170
C45-10-2	Lock Spring	1 Ea (1 ea)	100-Small Fab	5040658
C45-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5099970
C45-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5091709
C45-12-6	Retaining Ring	2 Ea (2 ea)	100-Small Fab	5091795
C45-13-1	Keeper Bushing	2 Ea (2 ea)	100-Small Fab	5054986
C45-13-2	Teflon Keeper, Spacer	2 Ea (2 ea)	100-Small Fab	5010278
C45-13-5	Keeper Spring	1 Ea (1 ea)	100-Small Fab	5097746
C45-3-1	Radial Bearing	2 Ea (2 ea)	100-Small Fab	5053218
C45-3-12	Latch Roller Bearing	1 Ea (1 ea)	100-Small Fab	5097909
C45-3-2-1	Snap Ring	2 Ea (2 ea)	100-Small Fab	5097903
C45-3-4-1	Retaining Ring	4 Ea (4 ea)	100-Small Fab	5097898
C45-3-5	Teflon Spacer	2 Ea (2 ea)	100-Small Fab	5068056
C45-3-8A	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5027245
				5078570

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

C-5-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab

5078801
 5089520
 5078803
 50511731
 5029335
 5107840
 5091820
 5083546
 5039335

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	1,051	0
	NAS1149F0563P	8	966	0
100-Small Fab	188-FSCS-1032-5/8	4	341	0
	600.1309-A	1	0	0
	600.1312	1	28	0
	AN4-23A	2	725	0
	AN5-21A	4	293	0
	C2-14-2	2	246	0
	C45-10-1	1	178	0
	C45-10-2	1	17	0
	C45-11-2	2	84	0
	C45-12-1	2	27	0
	C45-12-6	2	144	0
	C45-13-1	2	14	0
	C45-13-2	2	102	0
	C45-13-5	1	90	0
	C45-3-1	2	142	0
	C45-3-12	1	93	0
	C45-3-2-1	2	168	0
	C45-3-4-1	4	72	0
	C45-3-5	2	144	0
	C45-3-8A	1	38	0
	C45-3-8B	1	19	0
	C45-3-9	1	39	0
	C45-4-1	2	10	0
	C45-5-1	1	52	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	15	0
	MS21044N5	4	261	0
	MS27039-4-08	1	251	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ /Packaging Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Date : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order: _____ 		Part: 648,4704 Job No: 183196 Serial No/ Batch: S114435 Revision: 4 Inspection: _____ Exp Date: _____ Instructions: _____ Date: 09/28/18 Contact No: S114435 DART AEROSPACE HAWKESBURY, ON K6A 1K7 CANADA TEL: 1 800 692-5200 Email: sales@dartaero.com www.dartaerospace.com		
Root Cause				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
OTHER : _____				